

Work Order ID 51937

Wednesday, September 09, 2009 3:27:23 PM



Page 1

Item ID: D206-667-103

Accept



Setup Start



Revision ID: C

Stop



Item Name: Crosstube Fwd

Start Date: 9/11/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 9/30/2009 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

PD

Date:

09-9-09

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D206-667-143

Rev C

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels as per PPP D206-667-103 CHG004

2

HJ for BG 09/10/16

110

0.00



Packaging

Packaging

Memo

0.00

Packaging

120

0.00



BENDING MACHINE - CROSSTUBES

CNC Bend 2

Memo

0.00

CNC Alpha 160 Bender

Bend tube as per Dwg D206-667-143 using CNC bender program 206 B-fw and Folio FT

DP 9-10-5

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Page 2

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Start Date: 9/11/2009 Start Qty: 1.00



Cust Item ID:

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Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC15- Crosstube Dimensional Check	0.00							
QC	Memo	0.00							
Quality Control									
140	Crosstubes	0.00							
Crosstubes	Memo	0.00							
Crosstubes	1-Drill holes & ream using drill Jig DT8541 & DT8542 as per Dwg D206-667-143. Drill all (3) top holes. □3-Flip tube and switch drilling Jigs from right to left, left to right. Locate Jigs off existing holes using "T" pins. □4-Drill pilot holes using dr								
150	Crosstubes Chemical Conversion	0.00							
HandFXtube	Memo	0.00							
Hand Finishing Crosstubes									

09.10.06

1X 2 MB09-10-07

1 - AWM 9-10-07

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Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

2) 502/10/09

(XL)

q

170

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

2) 502/10/09

(XL)

d

180

Outsource process - NDT per QSI038 4.1

0.00



Outsource2

Memo

0.00

Outsource process - NDT

CROSSTUBES

CL 09/10/09 ①

210:10557

Work Order ID 51937

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Cust Item ID:

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Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

190



Packaging

Packaging

0.00

Memo

0.00

Packaging

Ensure copy of NDT results attached to work order.

Perkins

200



QC

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Quality Control

ml 09 10 13 ①

210



SprayPaint

SprayPaint

0.00

Memo

0.00

Spray Painting

1-Prime inside and outside crosstube as per QSI 005 4.2 2-Paint outside crosstube with White Imron as per QSI 005 4.2
Time: 9:45 ☐ Finish Time: 10:30 ☐ PAINT: ☐ Start
Time: 2:30 ☐ Finish Time: 3:30

ml 09 10 13 ①

Work Order ID 51937

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Item ID: D206-667-103

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Setup Start



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Stop



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Start Date: 9/11/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 9/30/2009 Req'd Qty: 1.00

Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

220



QC

Quality Control

QC14- Inspect Spray Paint

0.00

Memo

0.00

Wrap in plastic bag to protect from scratches

ST 09-10-14

230



Crosstubes

Crosstubes

Crosstubes

0.00

Memo

0.00

1-Install support using 0.03" to 0.06" thick layer of magnobond 6398 per QSI 015. Let cure for 12h after installation and prior to packaging. Note: (2) Aft holes should be facing up. □ A/R Magnobond 6398 : 11124989.02/2010
Install supports and clamps as Torque: ml 09 10 15 (1)

ml 09 10 14 (1)

240



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

2) 809/10/15

(10) /

Work Order ID 51937

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Item ID: D206-667-103

Accept



Setup Start



Revision ID: C

Stop



Item Name: Crosstube Fwd

Start Date: 9/11/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 9/30/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

250

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

9/14/10

260

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

1 9/10/16

270

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D206-667-103

Location: _____

PPP Rev: _____

D

9/10/16

Work Order ID 51937

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Item ID: D206-667-103

Accept



Setup Start



Revision ID: C

Stop



Item Name: Crosstube Fwd

Start Date: 9/11/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 9/30/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

280

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/10/19

ME
09-10-19

Picklist Print

Wednesday, September 09, 2009 3:27:29 PM

Page 1

Work Order ID: 51937

Parent Item: D206-667-103RevC

Parent Item Name: Crosstube Fwd


Comments:

Start Date: 9/11/2009

Required Date: 9/30/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN970-4  Washer		Purchased	No			100	Each	47.0000	12.0000			

m/12799 *C 9/11/09* *C*

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

47

104885

3

107242

3

107715

1

108077

2

108377

19

111724

3

112082

16

D206-667-
103TRNRevC

Manufactured No

230

Each

2.0000

1.0000



Crosstube Turning DetailL

Warehouse Loc Qty Loc Code

Location

Main Warehouse

FG

2

48461

1

48463

1

9-10-5

Picklist Print

Wednesday, September 09, 2009 3:27:29 PM

Work Order ID: 51937



Parent Item: D206-667-103RevC



Parent Item Name: Crosstube Fwd

Start Date: 9/11/2009

Required Date: 9/30/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2873-043RevA		Manufactured	No			230	Each	53.0000	2.0000			
Nut Plate Assembly												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	53	
45370	18	
45422	15	
50002	20	

ml 09 10 15

D2873-045RevA		Manufactured	No			230	Each	71.0000	2.0000			
Nut Plate Assembly												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	71	
45210	11	
46772	20	
50001	40	

ml 09 10 15

Picklist Print

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Work Order ID: 51937



Parent Item: D206-667-103RevC



Parent Item Name: Crosstube Fwd

Start Date: 9/11/2009

Required Date: 9/30/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2891-1RevA1		Manufactured	No			230	Each	81.0000	2.0000			

2.25 Support

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST	81	
40336	1	
<u>41198</u>	16	
43880	20	
45935	4	
46159	20	
50952	20	

mt 091014

MS21920-20

Purchased

No

230

Each

156.3000 4.0000



Clamp (per MIL-DTL-8783C)

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST	156.3	
103478	2	
106484	12	
109269	9.3	
110536	10	
<u>111281</u>	34	
112307	50	
112624	39	

mt 091014

Picklist Print

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Parent Item: D206-667-103RevC



Parent Item Name: Crosstube Fwd

Start Date: 9/11/2009

Required Date: 9/30/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
✓ AN5-30A 8		Purchased	No			260	Each	85.0000	4.0000	✓		
BOLT												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

85

110467

85

✓ AN5-32A

Purchased

No

260

Each

79.0000

4.0000



Bolt



Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

79

106242

3

106519

4

110363

17

111916

5

112082

50

11/0467

Rec'd 10/11/09

11/2082

Picklist Print

Wednesday, September 09, 2009 3:27:29 PM

Work Order ID: 51937



Parent Item: D206-667-103RevC



Parent Item Name: Crosstube Fwd

Start Date: 9/11/2009

Required Date: 9/30/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
✓ AN5-7A 6		Purchased	No			260	Each	81.0000	10.0000	✓		
Bolt												

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 81

110625 7

111668 24

112612 50

M11668

✓ AN960JD516
6

Purchased

No

260

Each

1,202.000

18.0000



M112794

P 9/14/10 @

Washer

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 1202

100564 2

106167 6

107534 34

107959 43

108246 46

108672 2

109059 49

109752 22

110363 46

110523 57

111279 43

112082 352

112314 500

Picklist Print

Page 6

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Work Order ID: 51937

Parent Item: D206-667-103RevC

Parent Item Name: Crosstube Fwd


Comments:

Start Date: 9/11/2009

Required Date: 9/30/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS20601-AD4W8 		Purchased	No			260	Each	328.0000	14.0000			
RIVET												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 328

108521 100

110399 28

112203 200

MS21042L5

Purchased

No

260

Each

1,311.000 4.0000

Nut

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 1311

110382 10

111636 301

112314 1000

ml 09 10 15

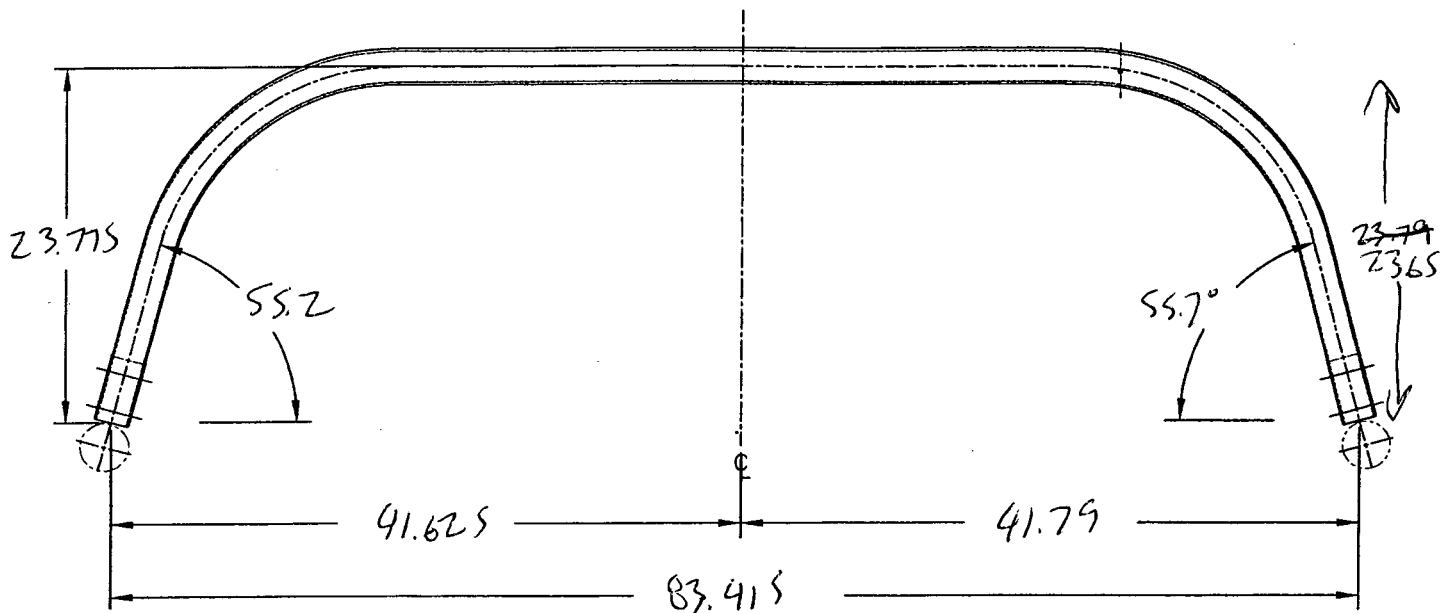
09/10/15 ①

ml 11/636

DART AEROSPACE LTD		Work Order:	51937
Description: Crosstube High Fwd (206L)		Part Number:	D206-667-103
Inspection Dwg: D206-667-143 Rev: C		Page 1 of 1	

23.39 CP 06.10.05

Required Dimension	Min	Max
Height	39.00	23.65
1/2 Span	41.79	42.05
Angle	54	56
Total Span	83.58	84.10



Comments
Tube bent high on one side & narrow
Tube fits in drill jig without issue.
Acceptable CP 05.10.06

QC15 Inspection	CP
Date	07.10.06

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	
B	09.06.26	Dimensions updated per Dwg Rev C	KJ	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Item	Qty -143	Part Number	Description
1	X	D206-667-143	CROSSTUBE ASSEMBLY (206L HIGH FWD)
2	1	D6002-115	CROSSTUBE
3	2	D2873-043	NUT PLATE
4	2	D2873-045	NUT PLATE
5	2	D2891-1	SUPPORT
6	4	D3595-063-395	RUBBER CUSHION
7	4	MS21920-20	CLAMP (OR MS21920-21)
8	14	MS20601AD4W8	RIVET (OR NAS9302B-4-8)
9	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 51937

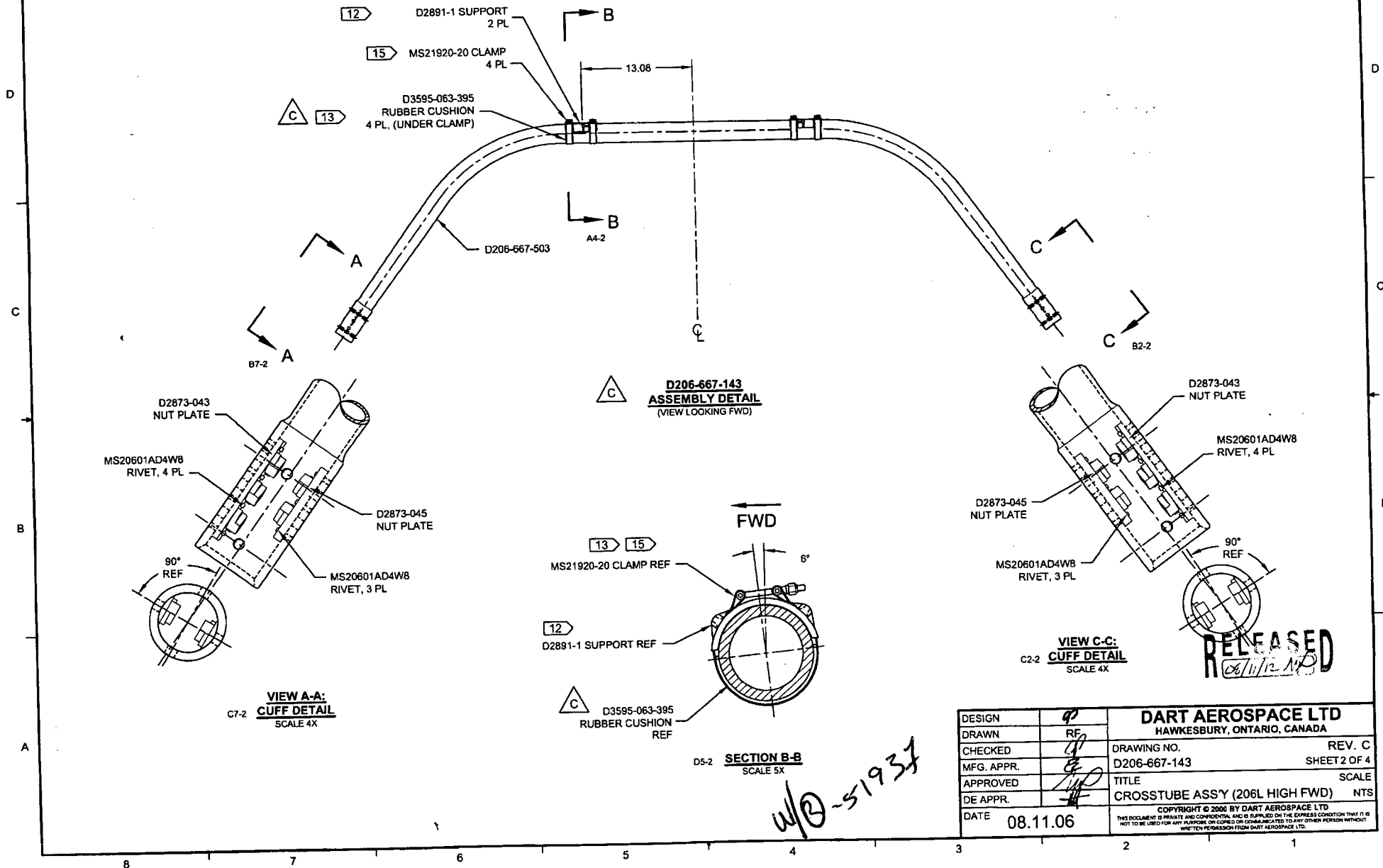
GENERAL NOTES:

- 1) MATERIAL: MANUFACTURED FROM D6002-115
FINISHED LENGTH = 104.98±0.020
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: SCRIBE DART PART NUMBER "D206-667-143" AND BATCH NUMBER ON INSIDE OF CUFF USING VIBRATING STYLUS.
- 7) WEIGHT: 15.5 lbs
- 8) PART IS SYMMETRIC ABOUT CENTERLINE.
- 9) RUN CUTTER OFF PART WHERE INDICATED. BLEND OUT EDGE LONGITUDINALLY. TRANSITION SHOULD BE SMOOTH.
- 10) BEND PROGRESSIVELY WITH A MINIMUM OF 10 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 11) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 12) INSTALL D2891-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 13) INSTALL MS21920-20 CLAMPS (OR -21) WITH D3595-063-395 RUBBER CUSHIONS TO SECURE THE D2891-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMP MECHANISMS ARE LOCATED ON CROSSTUBE SUPPORTS.
- 14) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS ARE SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

RELEASED
08/11/06

C	REVISE GENERAL NOTES/PART LIST (ZN D7-1); REORGANIZED VIEWS AND REFORMATTED DRAWING TO CURRENT STANDARDS. D3595-063-395 WAS D2856-400-694 (ZN D6-2 & A5-2); REMOVED REF. & ADD TOLERANCE (ZN D3-3, C4-3, C5-3); RELOCATED FLAG #6 (ZN A8-3) PER NCR 210; MOVED TURNING DETAIL & UPDATED TOLERANCE TO SHEET 4.	RF	08.11.06
B	ADD HOLES AND NUT PLATES FOR COMPATABILITY WITH BHT/AA SKUDTUBES	PH	05.07.26
A	NEW ISSUE	CP	00.11.17
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF	DRAWING NO.	REV. C
CHECKED	RF	D206-667-143	SHEET 1 OF 4
MFG. APPR.	RF	TITLE	SCALE
APPROVED	RF	CROSSTUBE ASS'Y (206L HIGH FWD)	NTS
DE APPR.	RF	COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMPILED OR COMPARED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	08.11.06		

8 7 6 5 4 3 2 1



u/b-51937

8

7

6

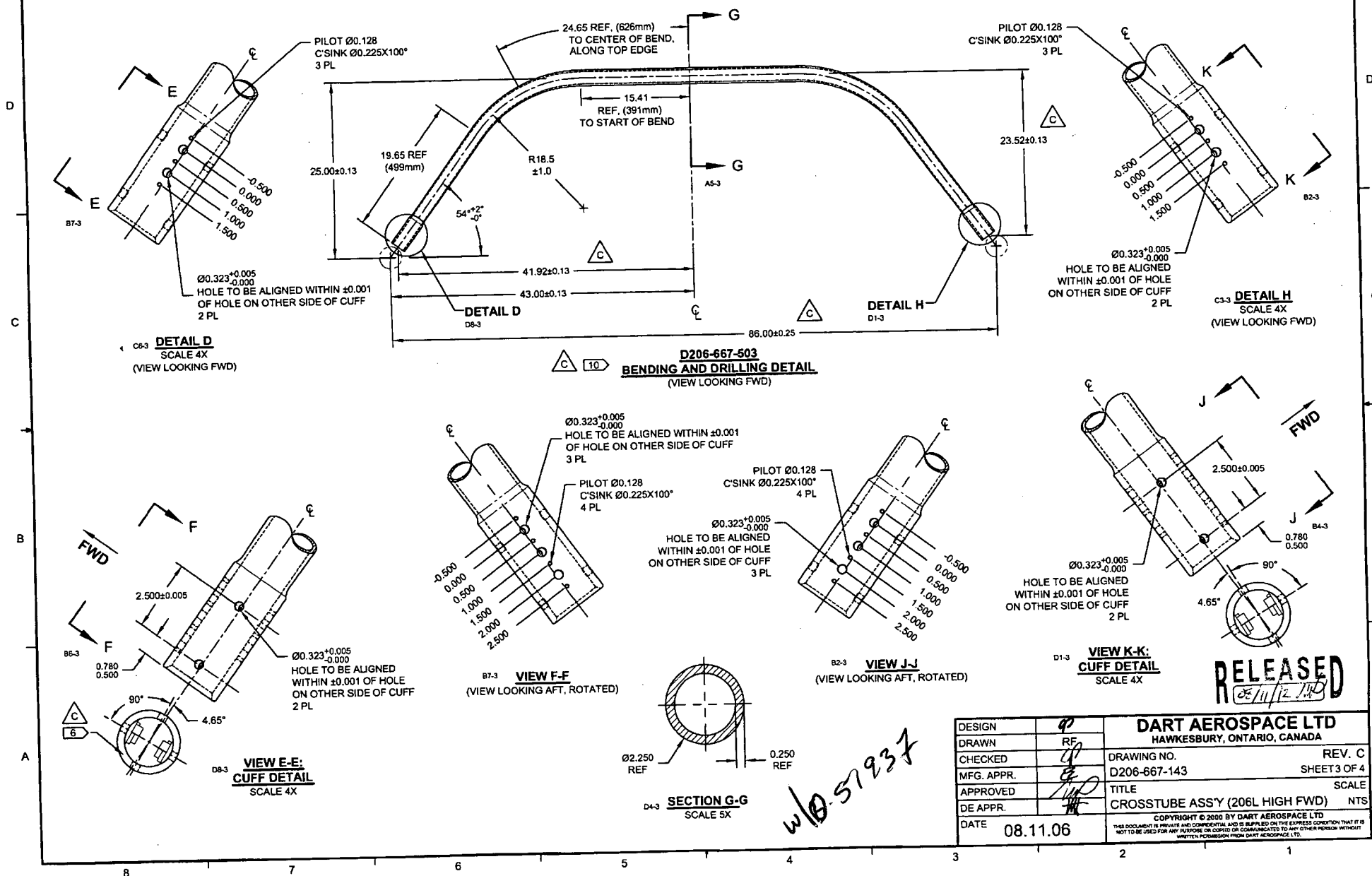
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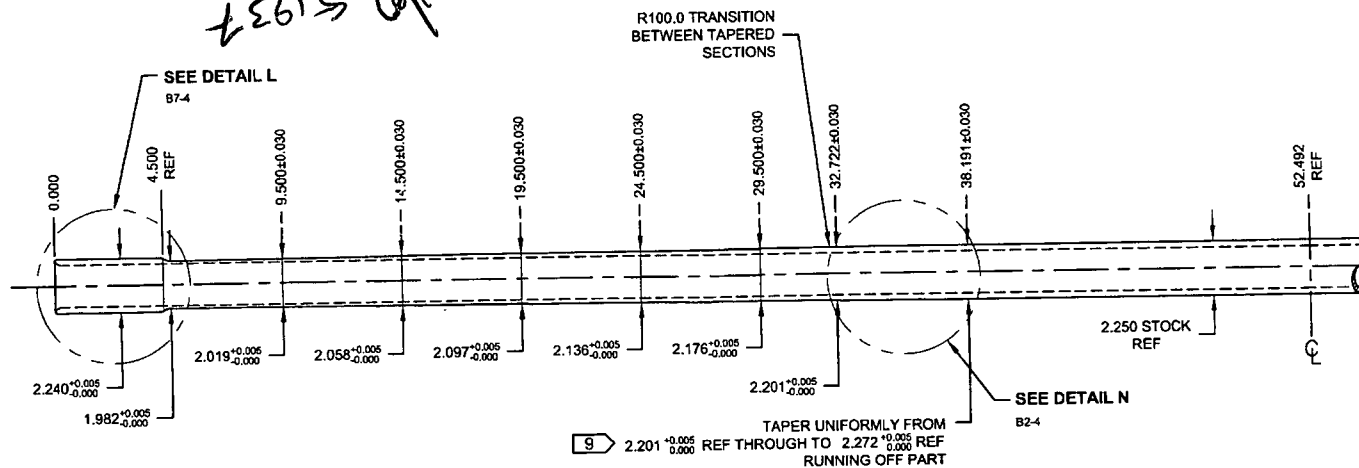
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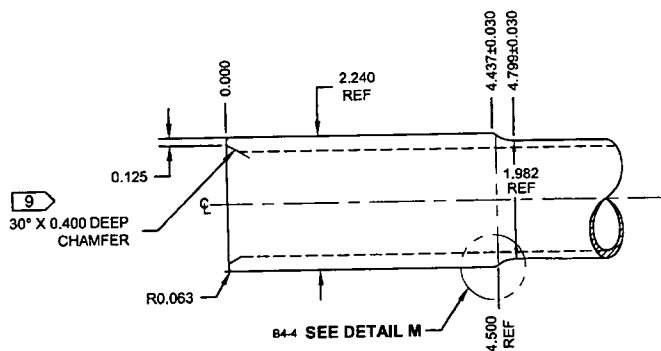
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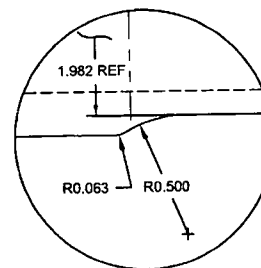
w/0-57937



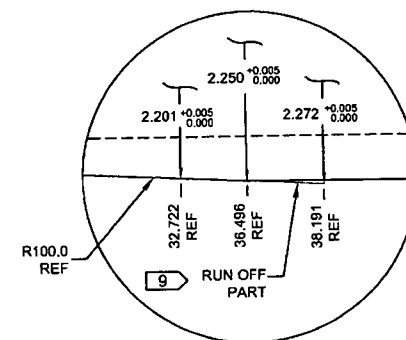
C TURNING DETAIL



**DETAIL L:
CROSSTUBE CUFF**
D7-4 NOT TO SCALE



**DETAIL M:
CUFF TRANSITION**
A6-4 NOT TO SCALE



**DETAIL N:
TAPER RUN OFF**
C4-4 NOT TO SCALE

RELEASED

DESIGN	97	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	47	DRAWING NO.	REV. C
MFG. APPR.	47	D206-667-143	SHEET 4 OF 4
APPROVED	47	TITLE	SCALE
DE APPR.	47	CROSSTUBE ASS'Y (206L HIGH FWD)	NTS
DATE	08.11.06	COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



LIQUID PENETRANT TEST REPORT

P- 1530

CLIENT	DART AEROSPACE	DATE	OCT-8-2009	PAGE	1	OF	
ATTENTION	LINDA/CHAUTEL	ACUREN JOB NO.	188-08-001567	TIME	AM	<input checked="" type="checkbox"/>	P
ADDRESS	1270 ABERDEEN ST, HAWKESBURY ON. K6H 1K7	PO/NO.	- 10557	WORK LOCATION	SAME		
PROJECT	F.P.I. on CROSS TUBES AND MACHINED PARTS	ACCEPTANCE STD.	ASTM 1417	REV./DATE	200		
ITEM(S) EXAMINED	10 CROSS TUBES 13 MACHINED PARTS						

JOB DESCRIPTION	PROCEDURE NO. LT-	REV./DATE	TECHNIQUE NO. LT-	REV./DATE	
PART NO.	STAINLESS STEEL	MATERIAL	ALUMINUM	THICKNESS	N/A
SCOPE	WET FLUORESCENT LIQUID PENETRANT INSPECTION CARRIED OUT 100% EXTERNAL				

TEST DETAILS	
METHOD	<input checked="" type="checkbox"/> FLUORESCENT <input type="checkbox"/> VISIBLE
FAMILY BRAND	MASNA FLUX
PENETRANT	2L-67 MINIMUM DWELL TIME 45 MIN.
PENETRANT REMOVER	H2O MINIMUM DRY TIME >10 MIN.
DEVELOPER	SKD 52 MINIMUM DWELL TIME 10 MIN.
DEVELOPER TYPE	<input checked="" type="checkbox"/> NON AQUEOUS <input type="checkbox"/> AQUEOUS <input type="checkbox"/> DRY
WATER WASH <input checked="" type="checkbox"/> SOLVENT REMOVABLE <input type="checkbox"/> POST EMULSION	
BLACK LIGHT S/N 16459 <input type="checkbox"/> OUTPUT > 1000 μ W/CM ² <input type="checkbox"/> AMBIENT < 1000 μ W/CM ²	
LIGHTING EQUIP. <input type="checkbox"/> FLASHLIGHT <input type="checkbox"/> TROUBLELIGHT <input type="checkbox"/> OUTPUT > 100 fc @ 5' <input type="checkbox"/> OTHER LABINO	
LIGHT METER S/N CAL DUE DATE	

TEST SURFACE	
SURFACE CONDITION	<input type="checkbox"/> AS GROUND <input type="checkbox"/> AS WELDED <input checked="" type="checkbox"/> MACHINED <input type="checkbox"/> SHOT BLASTED <input type="checkbox"/> CLEAN BARE METAL
SURFACE TEMPERATURE	<input type="checkbox"/> < -4°C/20°F <input type="checkbox"/> -4°C/20°F TO 10°C/50°F <input checked="" type="checkbox"/> 10°C/50°F TO 52°C/125°F <input type="checkbox"/> > 52°C/125°F

RESULTS-	<input checked="" type="checkbox"/> METRIC <input type="checkbox"/> IMPERIAL
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1 - W.O. 51939 - CROSS TUBE	X
1 - W.O. 51940 - CROSS TUBE	/
1 - W.O. 52054 - CROSS TUBE	/
1 - W.O. 52055 - CROSS TUBE	/
1 - W.O. 51297 - CROSS TUBE	/
1 - W.O. 51937 - CROSS TUBE	/
1 - W.O. 51938 - CROSS TUBE	/
1 - W.O. 52052 - CROSS TUBE	/
1 - W.O. 52053 - CROSS TUBE	/
1 - W.O. 50982 - CROSS TUBE	/
1 - W.O. 50983 - CROSS TUBE	/
13 - W.O. 51297 - STUDS	/

ALL PARTS EXAMINED. HAVE BEEN FOUND ACCEPTABLE TO STANDARD.

09 10 13

Scope of Services
The agreement of Acuren Group Inc. to perform services extends only to those services provided for in writing. Under no circumstances shall such services extend beyond the performance of the requested services. It is expressly understood that all descriptions, comments and expressions of opinion reflect the opinions or observations of Acuren Group Inc. based on information and assumptions supplied by the owner/operator and are not intended nor can they be construed as representations or warranties. Acuren Group Inc. is not assuming any responsibilities of the owner/operator and the owner/operator retains complete responsibility for the engineering, manufacture, repair and use decisions as to data or other information provided by Acuren Group Inc. In no event shall Acuren Group Inc.'s liability in respect of the services referred to herein exceed the amount paid for such services.

Standard of Care
In performing the services provided, Acuren Group Inc. uses the degree, care and skill ordinarily exercised under similar circumstances by others performing such services in the same or similar locality. No other warranty, express or implied, is made or intended by Acuren Group Inc.

SIGNATURES		DTR #	E-27843
CLIENT REPRESENTATIVE	MATTHEW MURDOCH	REPORT REVIEWED BY:	
TECHNICIAN (SIGNATURE):	Mike Johnston	NAME	INIT
NAME (PRINT):	Mike Johnston	NAME	INIT
CGSB LEVEL	2	CGSB LEVEL	
CGSB REG. NO.	6066	CGSB REG. NO.	